

Date: Wednesday, 26/11/2008 12:46:22 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SUPPORT ARM
 Job Number : 43761
 Estimate Number : 11488
 P.O. Number :
 This Issue : 26/11/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : MACHINED PARTS
 Previous Run : 40683
 Part Number : D31651
 Drawing Number : D3165 REV A
 Project Number : N/A
 Drawing Revision : A
 Material :
 Due Date : 05/12/2008 Qty: 8 Um: Each
 Written By :
 Checked & Approved By : JUD 08.11.26
 Comment : Est. A 02.09.18 New issue KJ
 Est Rev:B Moved Engraving to Haas step 08-09-24 Verified
 By:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0500X05000 6061-T6 Bar .500 x 5.00



Comment: Qty.: 1.4963 f(s)/Unit Total: 11.9700 f(s)

6061-T6 Bar .50" x 5.0"

Material: 6061-T6/T651 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) per (M6061T6B0.500x5000)

Batch M110167

Y.A 08/12/11

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut Blank: (17.00" x 5.00") +/- 0.030" x 0.500" thick

Grain along 17.000"

Y.A 08/12/11

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA277 & Dwg D3165-1

2-Deburr

3-Engrave batch number as per Dwg D3165

Y.A 08/12/11

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Y.A 08/12/12

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

JL 08/12/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SUPPORT ARM

Job Number: 43761

Part Number: D31651

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



(8)

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

FZ 08/12/18

7.0

POWDER COATING

POWDER COATING



M109996



(8X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:30
320 OF
11:00

M-1 08/12/19

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

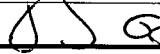
PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ST157



10.0

QC21

FINAL INSPECTION/W/O RELEASE



08/12/22

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W 08/12/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

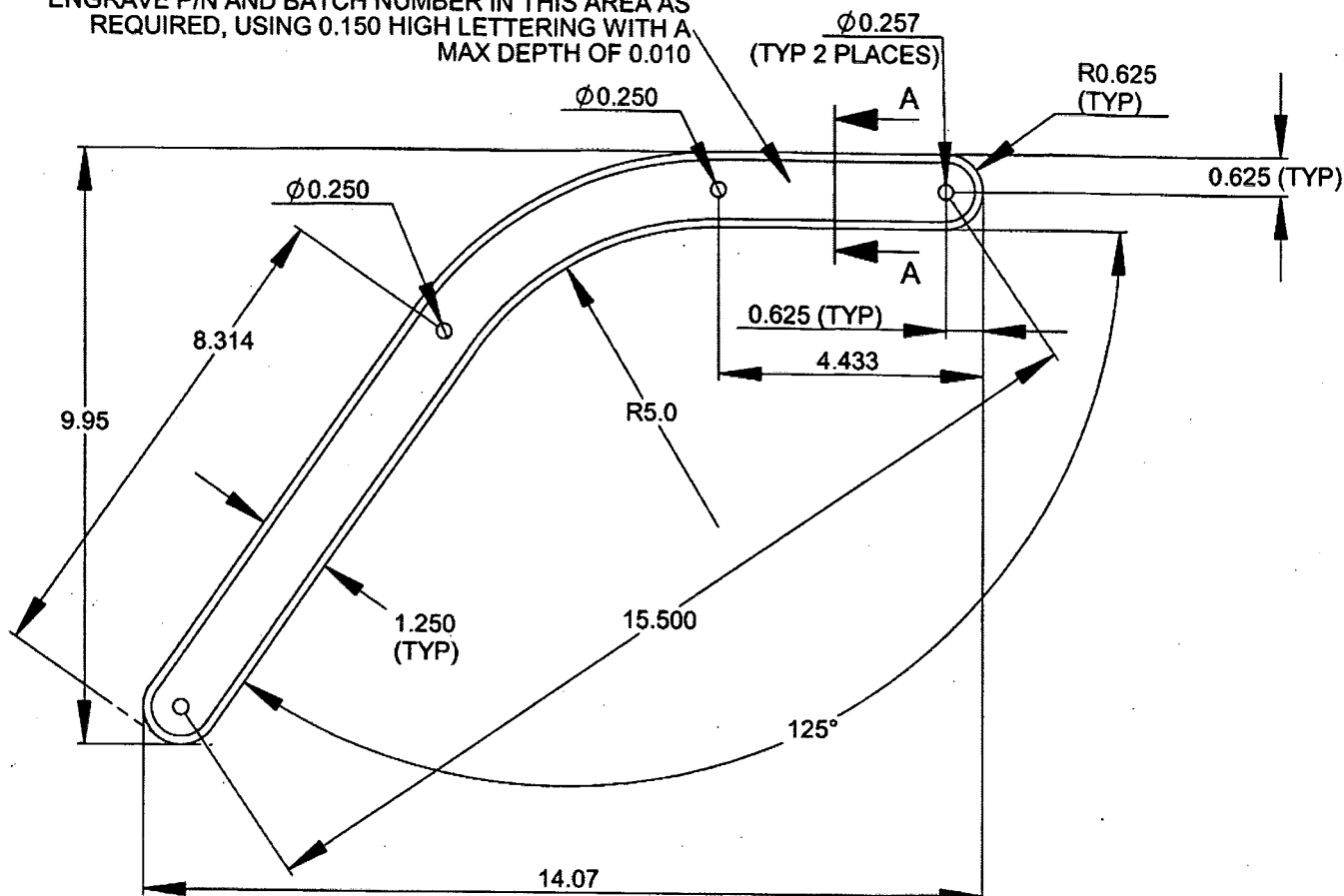
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

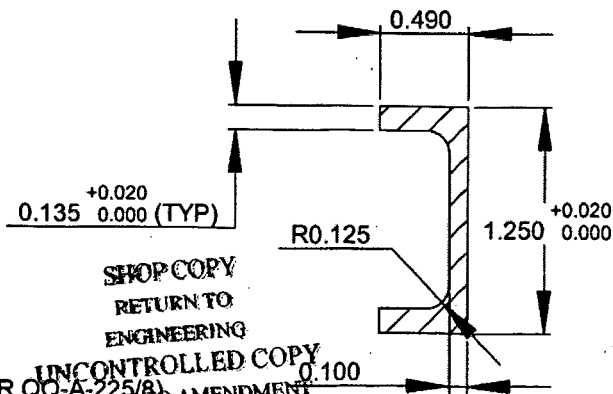


DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3165	REV. A SHEET 1 OF 1
DATE 02.07.09	TITLE SUPPORT ARM		SCALE 1:3
A	02.07.09	NEW ISSUE	

ENGRAVE P/N AND BATCH NUMBER IN THIS AREA AS REQUIRED, USING 0.150 HIGH LETTERING WITH A MAX DEPTH OF 0.010



RELEASED
02.08.07



D3165-1 SUPPORT ARM

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) PER M6061T6B
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 43165

SECTION A-A
SCALE (1:1)

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